Page 1 November-30-12 9:23:59 AM Item ID: D412-760-211 Accept \*N900040100\* Setup Start Revision ID: Stop Baggage Compartment Protector Item Name: Start Qty: 1.00 11/27/12 **Start Date: Cust Item ID:** Req'd Qty: 1.00 Required Date: 12/07/12 **Customer:** Reference: Run Process Plan: MLJ Date: 12-12-03 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Accept Reject Reject Tool # Plan Insp. Description Work Center ID **Run Hours** Code **Qty Qty** Number Stamp Draw Nbr **Revision Nbr** IIN-D412-760 100 0.00 mus 12-12-18 \*100\* DC Memo Document Control Photocopy bluefile & type labels per PPP D412-760-211 CHG 001 110 Pick Kit 0.00 \*110\* 0.00 Packaging Memo Packaging QC4-100% Inspect kits for completeness 120 \*120\* 0.00 12 1219 OC Memo

Quality Control

											DQA:	Date	2:	
NCR: \	/es	/ No				WORK ORDER NON-	cor	NFORN	ANCE / UPD	ATE			•	
11011.		,									QA Closed:	Date	2:	
						DISPOSITION		PARTMENT,	/PROCESS					
Work Orde	er: _					Rework	۱ ا		Skid-tube	Crosstube		Water Jet	Engineering	
Part I	۱o					Scrap Use-as-is		r	Machining of orming	Small Fab Finishing	ł	d. Eng. Coor.	Quality Other	
NCR I	No					Work Order Update		1	Large Fab	Composite Supplier				
Root					Descri	ption of work order update		Initial	Actio	on	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector	
Doc/Data													*	
Equip/Tooling														
Operator											<u> </u>			
Material														
Setup														
Other														
Process									,					
Supplier											İ			
Training			1				1							
Unapproved	П													
						F	AUI	LT CATE	GORY					
Landi	ng G	ear				General				·	-	_	_	
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced	
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld	
:	Crushed/Crimped.				Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	issing	Wrong Stock Pulled		
	$\Box$	Cuffs				Contamination		Mainte	enance		Part Moved			
	$\prod_i$	Heat Trea	it			Countersink		Mislabe	eled		Positioned '	<b>N</b> rong		
	$\prod_{i}$	nspection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss,	/Surge	Other	
	Ripples in Bend					Drill Holes		Offset		_	_	_		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

\*94123\*

Page 2

November-30-12 9:23:59 AM

Quality Control

November-30-12	2 9.23.39 AW	<i></i>										
Item ID: Revision ID:	D412-760-21	11	7 % - 3 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	Accept	*N900	040	100	)* s	etup	Start	*N.	<b>31</b> *
Item Name:	Baggage Com	partment Protector								Stop	*NS	32*
Start Date:	11/27/12	Start Qty: 1.00	*1*		Cust Item 1	ID:						
Required Date:	12/07/12	<b>Req'd Qty:</b> 1.00	*1*		Customer:							
Reference:			•									
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		F	Run	Start Stop	"IN F	₹1* •••
			Date:								"INF	<b> </b>
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
130				0.00					_		. )	0,6
*130* Packaging		Memo		0.00			•	-	X		gle	19
Packaging		Identify and Location: PPP rev:	pack for shipping as per	PPP D412-760-211								
140		QC21- Final Inspection -	Work Order Release	0.00					1	- l.	- 4	- U)
*140*				0.00					10	2//	2/2	0 1/2
QC		Memo		0.00						,		

N (3-30-12.

										DQA:	Date:			
NCR:	Yes / No				<b>WORK ORDER NON-</b>	COI	NFORM	MANCE / UP	DATE			<b>*</b>		
										QA Closed:	Date:			
Work Ord	ar:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
NCN	<b>V</b> O.		- <del></del>		Work Order opdate			Large Fab	Composite	J	Supplie: L			
Root				Descri	ption of work order update		Initial	Act	ion	Sign &				
Cause	Date	Step	Qty	(	or Non-conformance	Cł	nief Eng	Descr	iption	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved									•					
				<u> </u>	I	AUI	LT CATE	GORY						
Landi	Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped at n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		4	ion Incomplete ions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled  Other		
	Ripples in	ı Bena		1	Drill Holes	- 1	JUttset							

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

## **Picklist Print**

November-30-12 9:23:58 AM

Work Order ID:

94123

Parent Item:

D412-760-211

Parent Item Name:

Baggage Compartment Protector

**Start Date:** 11/27/12

Required Date: 12/07/12

Start Qty: 1.00

Required Qty: 1.00

												•
Comments:	IPP REV:A 12.10	.17 AS PER ECN	12-652	DD VERF:JL	M							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3628:1 Cupped Washer	Smp	Manufactured	No			110	Each	377.0000	(36)	36	~ 20	
				Location		Loc Qty	L	oc Code				
				FG		10						
				8358	37	10						
		\$ <del>-</del> 5		ST061		367			<del></del> =	- 20		
				8358	37	367				587		•
D3876-0 Protector - RH Fwd Wall	5m/3	Manufactured	No			110	Each	0.0000		1	9604	5 54 8
D3876-3 Protector - Fwd Wall	5m2	Manufactured	No			110	Each	0.0000		1	94077	SIP. §
D387625	SW3	Manufactured	No			110	Each	0.0000		1	9418	2 548
D3376-7		Manufactured	No			110	Each	1.0000		1	5)	~
1 loicetoi - Ait waii - S	$\sim$			<b>Location</b>		Loc Qtv	<u>L</u> e	oc Code	<del> </del>			
				ST099		1				<del></del>		
				7612	23	1					^	
Protector - Floor	3	Manufactured	No			110	Each	1.0000		1	A)	
				Location		Loc Qty	Lo	oc Code			,	
				ST139		1						
	^			8978	35	1				<u> </u>		
D3876-9 Sm	$\boldsymbol{artheta}$	Manufactured	No			110	Each	0.0000		1	94167	s s
D3876-13  Protector Door 5 M	S	Manufactured	No			110	Each	0.0000	7	1	9405	450 \$

										DQA:	Date:	2 -
NCR:	res / No				WORK ORDER NON-C	ON	<b>NFORN</b>	/ANCE / UP	DATE		_	*
										QA Closed:	Date:	
Work Orde	r'				DISPOSITION				AGAINST DE	PARTMENT,		
Part No.  NCR No.					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root	1	1		Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
					. 7	AUL	T CATE	GORY				
Landi	Cracks Crushed Cuffs Heat Tr	Not Conce  I/Crimped  eat  on Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		1	on Incomplete ions Incomplete/ enance led	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	_	Waves in	Extrusio	n	Drawing		4	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-30-12 9:23:58 AM

Work Order ID:

94123

Parent Item:

D412-760-211

Parent Item Name:

Baggage Compartment Protector

D3952-1

MS27039-1-04

**SCREW** 

Insert

Placard

Manufactured

No

**Start Date:** 11/27/12

Start Qty: 1.00

Required Date: 12/07/12

Required Qty: 1.00

Purchased

No

Location

ST076

110

110

Loc Qty

12 Each

14

2

Each

Loc Code

Loc Code

14.0000

3,447.0000

16875

Location Loc Qty ST305 3447 119638 3 120142 43 120910 121476 122815 3200 110 Purchased No

76875

84427

200 Each

61 121476 1,125.0000

30 120142

36

Location Loc Qty Loc Code ST381 1125 25+ 120273 120273 25 121500 100 11× 123839 123839 1000

NCR: Y	'es / 1	No			WORK ORDER NON-	CON	<b>NFORM</b>	MANCE / UPI	DATE			7
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,										QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DEI	PARTMENT	PROCESS	
Part No			Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstu  Machining Small F  Thermoforming Finishi  Large Fab Compos			Proc Rec/Stor	Engineering Quality Other			
Root				1	ption of work order update	1	nitial	ł	tion	Sign &		
Cause	Da	te Ste	o Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling				·								
Operator												
Material												
Setup	Щ	1 .										
Other												
Process	$\square$											
Supplier												
Training			1									
Unapproved				<u> </u>		- 4	TCATE	CORV		<u> L</u>	l	
					General	AUI	T CATE	GORT				
Landi	ng Gear Bend	!:			Bend		Grain			Ovalized		Pressure/Forced
		•	contric t	0/5	BOM/Route	$\vdash$	Hardwa	ara	<u> </u>	Over/Under	tolerance	Temperature/Cure
	_	Centre Not Concentric to O/S Cracks			Broken/Damaged	$\vdash$	4	ion Incomplete	-	Part Incorre	<del></del>	Weld
		s ned/Crimp	ad	-	Burrs	-	4 `	tions Incomplete/	/Unclear	Part Lost/M	<del>-</del>	Wrong Stock Pulled
	Cuffs	-	cu,	-	Contamination	$\vdash$	- 4	enance		Part Moved		7
	Heat Treat			Countersink		Mislabe			Positioned V	Vrong		
	—	ection Strip	in Tube	-	Cut Too Short		Misrea			Power Loss/		Other
	_	les in Bend			Drill Holes		Offset		<u>L.</u> .			
	H ''	ue Waves i		on	Drawing		4	Calibration				
	_ `				Finish		-i	Sequence				
	Turning Sequence											

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## HEFERENCE ONLY



IIN-D412-760 Page 41 of 42

## DART AEROSPACE LTD.

Qty -111	Qty -113	Part Number	Description
X	110	D412-760-111	AFT CABIN WALL AND PYLON PROTECTOR KIT
	X	D412-760-113	AFT CABIN WALL AND PYLON PROTECTOR KIT
1	1	D3933-1	LH AFT CABIN WALL PROTECTOR
1	1	D3933-2	RH AFT CABIN WALL PROTECTOR
1		D3935-1	LH PYLON PROTECTOR
1		D3935-2	RH PYLON PROTECTOR
	1	D3935-3	LH PYLON PROTECTOR
	. 1	D3935-4	RH PYLON PROTECTOR
14	. 14	D3942-1	ANGLE
10	10	D3942-3	CLIP.
4	4	MS27039-4-10	SCREW
6	6	MS27039-4-14	SCREW
6	6	MS27039-5-08	SCREW
8	8	MS27039-5-12	SCREW

Qty-	Qty 2-213	Qty -215	Qty -217	Part Number	Description
X	16735			D412-760-211	BAGGAGE COMPARTMENT PROTECTOR KIT
	X			D412-760-213	BAGGAGE COMPARTMENT CEILING PROTECTOR KIT
		X		D412-760-215	CARGO FLOOR PROTECTOR KIT
			х	D412-760-217	LIGHTWEIGHT BAGGAGE COMPARTMENT PROTECTOR KIT
	4		1		
36=	7	8	=	=D3628=1=====	:CUPPED:WASHER
0			43	D3628-5	CUPPED WASHER
				:D3876-1⊃	_RH_EORWARD:WALL PROTECTOR
<b>C</b> 1==				D3876-3	*FORWARD WALL PROTECTOR
1-				-D3876-5> -	-LH.WALL PROTECTOR>
4==				=D3876-7	FAFT-WALLIPROTECTOR >
			-	-D3876-9	-RH AFT-WALL PROTECTOR
·4=	20000	_1=	===	D3876-1-1	-FLOOR:PROTECTOR
F1-				-D3876-13	-DOOR-PROTECTOR
<==		_1=		-D3952-1	-PLACARD
			1	D3952-3	PLACARD
	1			D4438-1	CEILING PROTECTOR
			1	D4640-1	RH FWD WALL PROTECTOR
			1	D4640-3	FORWARD WALL PROTECTOR
			1	D4640-5	LH WALL PROTECTOR
			1	D4640-7	AFT WALL PROTECTOR
		11.2	1	D4640-9	RH AFT WALL PROTECTOR
			1	D4640-11	FLOOR PROTECTOR
			1	D4640-13	DOOR PROTECTOR
			1	D4640-15	CEILING PROTECTOR
	-7-				
-36=	===	=8=	=36-	_80-004-2-6	±INSERT
	7		7	80-004-2-8	INSERT
<b>~</b> 36=		_8_	=-36	-MS27039=1-04===	-SCREW
	7		7	MS27039-1-05	SCREW
	3		3	MS27039-1-10	SCREW
	6		6	NAS1149F0363P	WASHER (AN960-10)

COPYRIGHT © 2007 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **F**Date: 12.08.30